

Date: Thursday, 3/8/2007 3:40:55 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CHAFING SHIELD
Job Number	: 31147		
Estimate Number	: 10840		
P.O. Number	: <i>N/A</i>	Part Number	: D31891
This Issue	: 3/8/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3189 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 30201	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/3/2007 Qty: 20 - Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.03.08		
Comment	: Est. B 05.08.22 No longer made in-house KJ/JLM Est Rev:C 06-03-24 Rolling Now made in House JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.3360 sf(s)/Unit Total : 6.7200 sf(s)

304/316 SS .020" Sheet

(M304S25GA)

Batch: *M101873**M101873 PTO**M102376**FF 07-03-12**20*

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut to size as per Dwg D3189

*FF 07-03-12**20*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr &amp; Grind Rads as per Dwg D3189

2-Roll as per Dwg D3189

*FF 07/03/14**20*

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1




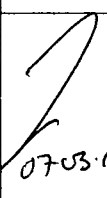
Identify and Stock

Location: \_\_\_\_\_

*[Signature]* 07/03/15 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/12	2	cut 0.020" instead of 25 GA  N COS		<del>Identify</del> & Replace Identify: Stock on shelf. Ensure to measure the material thickness & verify the thickness	07/03/12 FF	 07-03-14	 05/04/12	 07-03-14

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CHAFING SHIELD

Job Number: 31147

Part Number: D31891

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



22

Comment: FINAL INSPECTION/W/O RELEASE

07/03/19

Job Completion



U 07-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

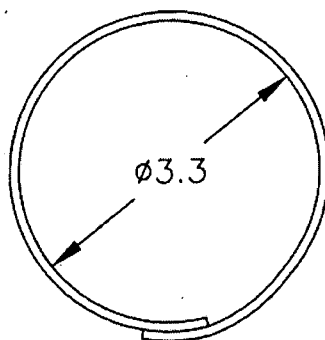
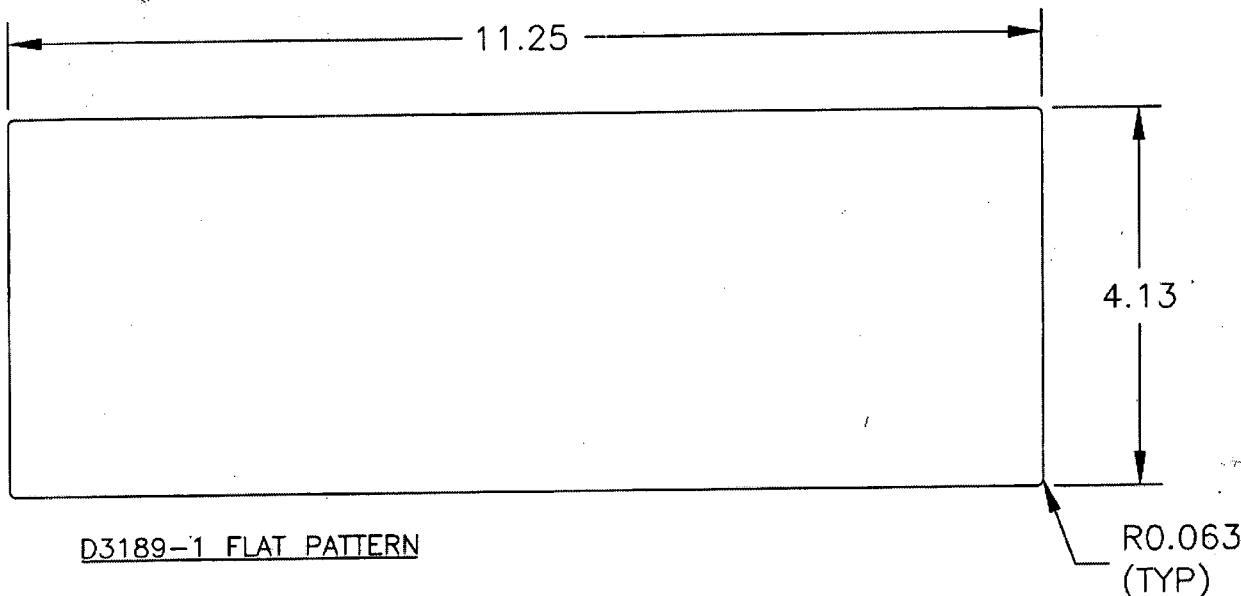
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3189	REV. A SHEET 1 OF 1
DATE 03.05.08		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	

RELEASED  
03.05.08



D3189-1 ROLLING DETAIL  
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31147

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